WHAT IS CLAIMED IS:

1. A method for producing a friction plate having oil grooves communicating between the internal periphery and the external periphery, by fixing friction material segments formed from a friction material to a core plate, the method comprising:

forming said oil grooves by plastic working of said friction material and fixation of said friction material segments with predetermined gaps therebetween to said core plate.

2. A method for producing a friction plate according to claim 1, wherein said oil grooves are formed on the surface of said friction material with a heated press used for final adhesion after said friction material segments are fixed with gaps therebetween.

3. A method for producing a friction plate according to claim 1, wherein after said oil grooves are formed by plastic working of said friction material, said friction material segments are formed by punching, and said friction material segments with said predetermined gaps are fixed to said core plate.

4. A method for producing a friction plate according to claim 1, wherein said friction material of

a band shape is punched to simultaneously form said friction material segments and said oil grooves, and said friction material segments with said predetermined gaps are fixed to said core plate thereby forming said oil grooves.

5. A method for producing a friction plate according to claim 1, wherein said friction material segments with said predetermined gaps are fixed to said core plate after grooves are formed by plastic working.

6. A method for producing a friction plate having oil grooves communicating between the internal periphery and the external periphery, by fixing friction material segments formed from a friction material to a core plate, the method comprising:

forming said oil grooves by cutting of said friction material and fixation of said friction material segments with predetermined gaps therebetween to said core plate.

7. A method for producing a friction plate according to claim 6, wherein said friction material of a band shape, provided in advance with an oil groove by cutting, are punched to form grooved friction material segments, and said grooved friction material segments with gaps are fixed to said core plate, thereby forming

said oil grooves.

8. A method for producing a friction plate having oil grooves communicating between the internal periphery and the external periphery, by fixing friction material segments formed from a friction material to a core plate and, the method comprising:

fixing said friction material segments with predetermined gaps to said core plate; and

then forming said oil grooves by cutting.

9. An apparatus for producing a friction plate having oil grooves communicating between the internal periphery and the external periphery, by fixing friction material segments formed from a friction material to a core plate, the apparatus comprising:

means for punching the friction material of a band shape to obtain plural friction material segments;

means for holding said friction material segments by stacking on a metal mold or a jig and pushing said friction material segments in succession to a side opposite to said metal mold; and

means for pressing and adhering said friction material segments to said core plate;

wherein said oil grooves are formed by plastic working of said friction material and fixation of said friction material segments with predetermined gaps

therebetween to said core plate.

10. An apparatus for producing a friction plate having oil grooves communicating between the internal periphery and the external periphery, by fixing friction material segments formed from a friction material to a core plate, the apparatus comprising:

means for punching the friction material of a band shape to obtain plural friction material segments;

means for holding said friction material segments by stacking on a metal mold or a jig and pushing said friction material segments in succession to a side opposite to said metal mold; and

means for pressing and adhering said friction material segments to said core plate;

wherein said oil grooves are formed by cutting of said friction material and fixation of said friction material segments with predetermined gaps therebetween to said core plate.

11. A friction plate formed by fixing friction material segments formed from a friction material to a core plate and having oil grooves communicating between the internal periphery and the external periphery, wherein:

said oil grooves are formed by plastic working of said friction material and fixation of said friction

material segments with predetermined gaps therebetween to said core plate.

12. A friction plate formed by fixing friction material segments formed from a friction material to a core plate and having oil grooves communicating between the internal periphery and the external periphery, wherein:

said oil grooves are formed by cutting of said friction material and fixation of said friction material segments with predetermined gaps therebetween to said core plate.

13. A friction plate formed by fixing friction material segments formed from a friction material to a core plate and having oil grooves communicating between the internal periphery and the external periphery, wherein:

said oil grooves are formed by fixing said friction material segments with predetermined gaps therebetween to said core plate and then effecting cutting.